



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RB877212-08
Job Sheet 192385



Part No: RB877212-08

Job Qty: 1 pcs

Part Name: Tail Rotor Bearing Cutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *Order 13636*

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	5/1/19		0.00	0.10	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	5/1/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	5/1/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S190983



Part: RB877212-08

Job No: 192385

Serial No/Batch: S190983

Revision: D

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/17/19

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
130 QC 21 - FG	1 pcs	5/1/19	0.00 0.00		QC 21 - FG - 21	DAG
					QC 21 - FG - 70	21
					QC 21 - SA - 53	53

Part Op 100 - 1-Pick bag and tag. 2-Use Loctite 495 to glue placard.
 Descriptions:

JUN 17 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1060-E	Case	1 pcs (1 ea)	100-Small Fab - 1	5175-835
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab - 1	5021048
RB877212-08-16	Removal and Installation Tool Assembly	1 pcs (1 ea)	100-Small Fab - 1	5064996
RB877212-08-2	Bearing Cutter Tool Assembly	1 pcs (1 ea)	100-Small Fab - 1	
RB877212-08-28	Content Placard	1 pcs (1 ea)	100-Small Fab - 1	5170491

Job Allocations

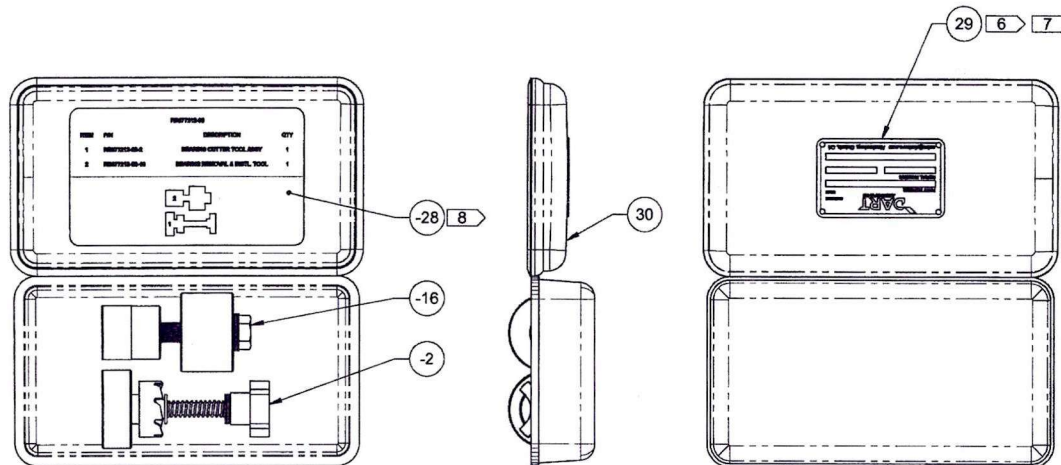
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1060-E	1	5	0
	RB41011	1	373	0
	RB877212-08-16	1	0	0
	RB877212-08-2	1	0	0
	RB877212-08-28	1	0	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-2	1	RB877212-08-2	BEARING CUTTER TOOL ASSY
-16	1	RB877212-08-16	BEARING REMOVAL & INSTALLATION TOOL ASSY
-28	1	RB877212-08-28	CONTENT PLACARD
29	1	RB41011	DART PLACARD
30	1	PELICAN #APP-1060-E	PELICAN CASE 1060



RB877212-08 TAIL ROTOR BEARING CUTTER

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED
- 7) HOT GLUE THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA
- 8) HOT GLUE THE CONTENT PLACARD ONTO THE CASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192385

SEE PREVIOUS REVISION FOR MORE INFORMATION
UPDATED DRAWING TEMPLATE
ADDED ITEMS -28, 29 & 30
-1 DIM WAS $\emptyset 0.498$ TAPPER IS $\emptyset 0.5000 \pm 0.0008/-0.0000$. DIM WAS 0.750 IS 0.75. DIM WAS 3.850 IS 3.85. DIM WAS 0.400 IS 0.40. DIM WAS 0.500 IS 0.56. DIM 0.250 & 2.000 DELETED. ADDED DIM R0.008 MAX, 0.02 X 45.0° CMF & 2.90
-3 DIM WAS $\emptyset 0.500$ IS $\emptyset 0.5000 \pm 0.0000/-0.0008$. ADDED DIM 0.03 X 45.0° CMF 4 PL. FINISH WAS BLACK ANODIZE IS RED ANODIZE. T/N ENGRAVING WAS RB877212-8 IS RB877212-08-2
-7 DIM WAS 1.430 ± 0.002 IS 1.430 ± 0.001 . DIM WAS 0.38 IS 0.372. DIM WAS 0.18 IS 0.175. ADDED DIM 0.216 & R0.06. DELETED DIM 5". DELETED NOTE MACHINE TO 1.445 $\pm 0.005/-0.003$ GRIND TO SIZE AFTER HEAT TREAT. ADDED FINISH BLACK OXIDE
-9 DIM WAS $\emptyset 0.312$ IS $\emptyset 0.313 \pm 0.010/-0.000$. ADDED DIM R0.008 MAX & 0.02 X 45.0° CMF 3 PL. MATERIAL WAS STRESSPROOF IS 4140 (28-32). FINISH WAS BLACK OXIDE IS ZINC PLATE
-17 DIM WAS $\emptyset 1.350 \pm 0.002$ IS $\emptyset 1.350 \pm 0.001$. ADDED DIM R0.008 MAX 2 PL & 0.03 X 45.0° CMF 3 PL
-21 DIM WAS $\emptyset 0.500$ IS $\emptyset 0.510 \pm 0.010/-0.000$. ADDED DIM R0.02 & 0.03 X 45.0° CMF 3 PL. DIM WAS 1.350 IS 1.35. DIM WAS 0.850 IS 0.85. FINISH WAS BLACK ANODIZE IS RED ANOZIZE
-27 WAS MODIFIED PART IS MACHINED PART

19-652 MBB

REV.	DESCRIPTION	ECN #	BY
DESIGN	MBB		
DRAWN	MBB		
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	WY		
DATE	3/21/2019		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
TOOL PART # RB877212-08	REV. D
TITLE TAIL ROTOR BEARING CUTTER	SHEET 1 OF 11
SCALE NTS	①
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					